



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Deviation

RBW5605G00551-3G-3

Job Sheet 196079



REPRINT

Part No: RBW5605G00551-3G-3

Job Qty: 1 pcs

Part Name: Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Due Date: 10/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5605G00551-3G Rev C IPP Rev A 18.03.23 New issue DP Verify DD/IPP Rev. B 19.06.03 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	1	10/26/19	10/26/19	0.50	0.20	Conventional Lathe - 1		
		pcs					Conventional Lathe - 2		
110	QC 2	1	10/26/19	10/26/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S212819



Part: RBW5605G00551-3G-3

Job No: 196079

Serial No/Batch: S212819

Revision: C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartero.com
www.dartaerospace.com

Date: 09/26/19

Plex 9/17/19 1:45 PM Dart.Guerin.Kimberley

rol/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 1/4

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Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
112 - 1-Machine as per drawing. 2-Remove handles from shank, identify accordingly and stock in small fab for re assembly later.
113 - QC2- Inspect parts off machine FAI/FAIB
120 - (QC8- Inspect parts - second check) Engrave T/N and/or P/N using MARKTRONIC engraver as per DWG.
121 - Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required
122 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)
123 - (QC6- All purchased or subcontracted products)
124 - 1-Re install previously removed handles.
125 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) IDENTIFY AND STOCK
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
JP0204R	Phillips Round Bar Scwdriver 4"	1 Ea (1 ea)	100-Conventional Lathe - 1	S189506

GA091

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	JP0204R	1	2	0

Part Specifications

Specifications could not be found.

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RBW5605G00551-3G-3

Job Sheet 196079



Part No: RBW5605G00551-3G-3

Job Qty: 1 pcs

Part Name: Handle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Due Date: 7/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5605G00551-3G Rev C IPP Rev A 18.03.23 New issue DP Verify DD/IPP Rev. B 19.06.03 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	5 pcs	7/26/19	7/26/19	0.50	1.00	Conventional Lathe - 1		/
							Conventional Lathe - 2		
110	QC 2	5 pcs	7/26/19	7/26/19	0.00	0.00	QC 2 - 1		/ 6/9/11
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S212819



Part: RBW5605G00551-3G-3

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Instructions:

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Email: sales@dartaero.com
www.dartaerospace.com

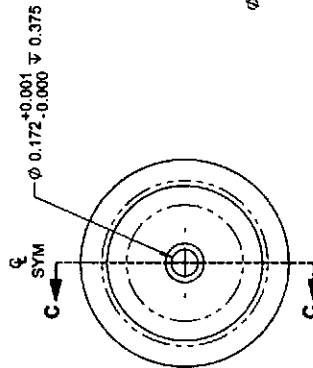
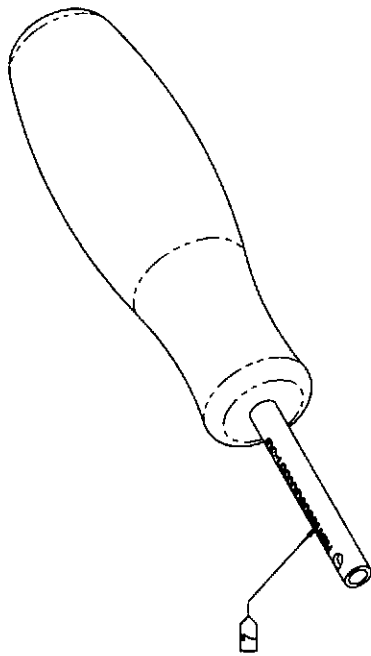
Date: 09/11/19

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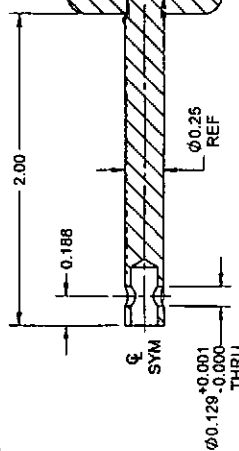
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 68	
112	Conventional Mill - 1 - B4B	5 pcs	7/26/19	0.00 1.00	Conventional Mill - 1 - B4B	NOT REQ 1/19/14
					Conventional Mill - 2 - B4B	
113	QC 2	5 pcs	7/26/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	5 pcs	7/26/19	0.00 0.00	QC 8 - 12	1/19/09/14
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	

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SHOP COPY
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 SUBJECT TO COMMENT
 WORK ORDER
 NO. 19607A M05
 190605



RBW5605G00551-3G-3 HANDLE



SECTION C-C

NOTES:
 1) MATERIAL: PROTO#JP0204R OR EQUIV (#2 PHILIPS SCREWDRIVER 4")
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = ± 0.1 / ± 0.1
 X.XX = ± 0.01 / ± 0.5
 X.XXX = ± 0.005 / ± 0.1
 X.XXXX = ± 0.0005 / ± 0.05
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) REMOVE ALL SHARP EDGES AND BURRS
 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK TIN. *RBW5605G00551-3G* AS SHOWN

DESIGN	VM	VM	DART AEROSPACE LTD	REV. C
DRAWN	VM	KPT	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 3
CHECKED	DD	DD	TOOL PART #	SCALE: 1:1
MFG. APPR.	WJ	WJ	RBW5605G00551-3G	NTS
APPROVED			TITLE	
DATE	2019-05-31		FILLER INSTALLATION TOOL	

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Entered: Quero Date: Oct 3/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7382

Route update only ☐



Job: <u>196079</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>RBW5605G-0551-3G-3</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>09.11.2019</u>	Sequence #: <u>100</u>	QTY Affected: <u>5</u>		MRB (QSI042) <u>WJF</u>			
Description Work Order Deviation		Disposition					
DIM WAS $\phi D.172 + 0.001/-0.000$ IS 8-32 UNC		THIS DEVIATION IS ACCEPTABLE					
SCREWDRIER SHANK MUST BE REMOVED, FINISHED BLACK OXIDE, AND THEN REINSTALLED. WITH SCREWDRIER HANDLE		Completed By <u>19/09/14</u> Lead hand / Supervisor <u>19/09/14</u>					
QC / QA Coordinator <u>DAS</u> <u>68</u> SEP 16 2019							
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐					
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☒					
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐					
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>196079</u>		DEPARTMENT/PROCESS		☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality	
Part No. <u>RBW56060051-363</u>		☐ Cross tube ☐ Small Fab ☐ Finishing		☒ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging	
DISPOSITION		QTY Affected: <u>4</u>		Disposition	
Rework ☐ Scrap ☒ Use-as-is ☐		Sequence #: <u>100</u>		Completed By <u>19/10/18</u> Lead hand / Supervisor <u>19/10/18</u> QC / QA Coordinator <u>19.10.17</u>	
Date: <u>19.10.17</u>		Description Work Order Deviation			
machining was following w/o drawing and tapping into a hard metal shaft, resulting in tap breaking off.		- Scrap destroy 4 parts - New design will be implemented with a new revision design to be updated on the rev E version PD.			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☒			
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
Other/Details:		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044523



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044523

PO Date: 9/17/19

Due Date: 9/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198284	RBT18635-3	Spud -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$5.96/pcs	\$23.84
2	198282	RBT18635-1	Adapter Bushing -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$0.99/pcs	\$3.96



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PURCHASE ORDER

POHB044523



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200410	RBW5605G00551-3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.11/pcs	\$1.11
4	198052	RBW6405G04132-3G-6	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	9/25/19	5 pcs	0 pcs	5 pcs	\$9.90/pcs	\$49.50
5	196252	RBSC7028-P-5	Cutter Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	10 pcs	0 pcs	10 pcs	\$2.87/pcs	\$28.70



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199561	RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	6 pcs	0 pcs	6 pcs	\$8.43/pcs	\$50.58
7	196076	RBW5605G00251-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.51/pcs	\$1.51
8	196078	RBW5605G00351-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.48/pcs	\$1.48



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	196079	RBW5605G00551-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.41/pcs	\$1.41
Grand Total:											\$162.09

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/19 11:02 AM Dart.Guerin.Kimberley



GROUPE
altech

Certificat de Conformité / Certificate of Compliance
(022506-2)

FM-1020 Rev 20151005

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

022506 - 2

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
24-Sep-2019		Jigar Patel		POHB044523				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18635-3 Rev.	RBT18635-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	4	4	0	0	0
2	RBT18635-1 Rev.	RBT18635-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	4	4	0	0	0
4	RBW6405G04132-3G-6 Rev.	RBW6405G04132-3G-6 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5	0	0	0
7	RBW5605G00251-3G-3 Rev.	RBW5605G00251-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0
8	RBW5605G00351-3G-3 Rev.	RBW5605G00351-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0
9	RBW5605G00551-3G-3 Rev.	RBW5605G00551-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0

RECEIVED

SEP 24 2019

DART AEROSPACE LTD.

(022506-2)

022506- 2

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

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